

Work Order ID 63333-2

Wednesday, October 27, 2010 3:51:14 PM

Page 1

Item ID: D3910-3

Revision ID:

Item Name: Crosstube Lug

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 10-10-28 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to 1.450" Long

cut @ Mebec

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV:

DWG REV:

DEBURR

Issue I.D to Mebec 710 13000
Mechanic for drug D3910 Rev B.

CL 10/11/24 30

Purchasing

Work Order ID 63333

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Page 2

Item ID: D3910-3

Accept

Revision ID:

Item Name: Crosstube Lug

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Reviewing

Review & Inspect for ~~drag~~ ^{first} sample

10/27/29 (10)

130

QC2 Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

8/10/130

(10)

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

all 10/11/30

x10 * 0

Work Order ID 63333

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Page 3

Item ID: D3910-3

Accept

Revision ID:

Item Name: Crosstube Lug

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M.115951 START: 2:00
Memo COAT: 3:20
FINISH: 2:30

0.00

10. BL 10-11-30

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> H 10/11/30

10 8

170



Packaging

Packaging

Identify as per dwg & Stock Location 507

0.00

Memo

0.00

10/11/30 SF 10x

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Page 4

Item ID: D3910-3

Accept

Revision ID:

Item Name: Crosstube Lug

Start Date: 10/27/2010 Start Qty: 4.00

Required Date: 11/11/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/01 AJ

BS 10-12-1
(10)

Picklist Print

Wednesday, October 27, 2010 3:51:18 PM

Page 1

Work Order ID: 63333



Parent Item: D3910-3



Parent Item Name: Crosstube Lug

Start Date: 10/27/2010

Required Date: 11/11/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423  Lug Extrusion		Manufactured	No			100	f	316.4039	0.13	0.547368	39		



C21011125

Location

Loc Qty

Loc Code

MAT06

316.4039265

43722

180

45800

136.403926

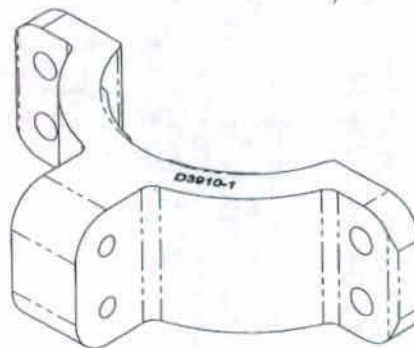
3.9

D3910-3P

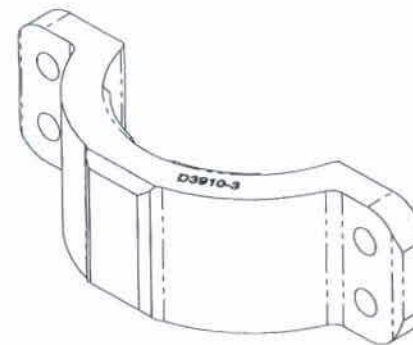
x 30

Ce 10/27/10 (30)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 63333
2810-10-28



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 \pm 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

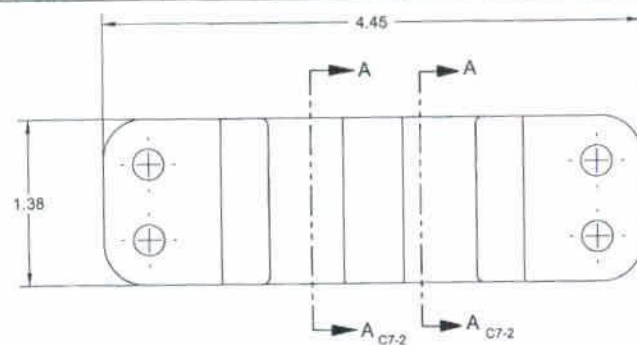
RELEASED
 2010-03-22
 MP

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3) REASON: SEE TR-D350-607-2		JPH	10.03.16
A	NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3910 TITLE X-TUBE LUG (350) <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. ANY REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD IS STRICTLY PROHIBITED.</small>		
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.16		REV. B SHEET 1 OF 3 SCALE NTS	

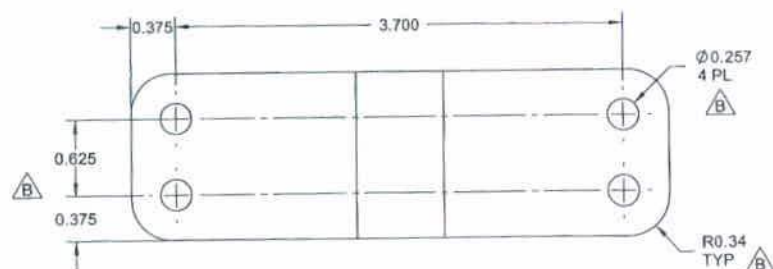
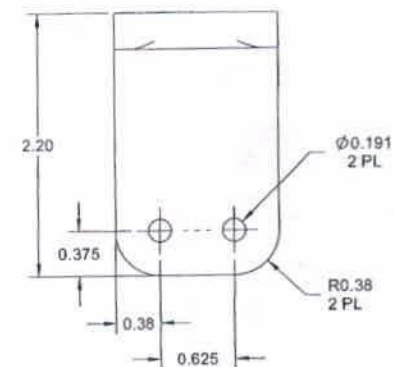
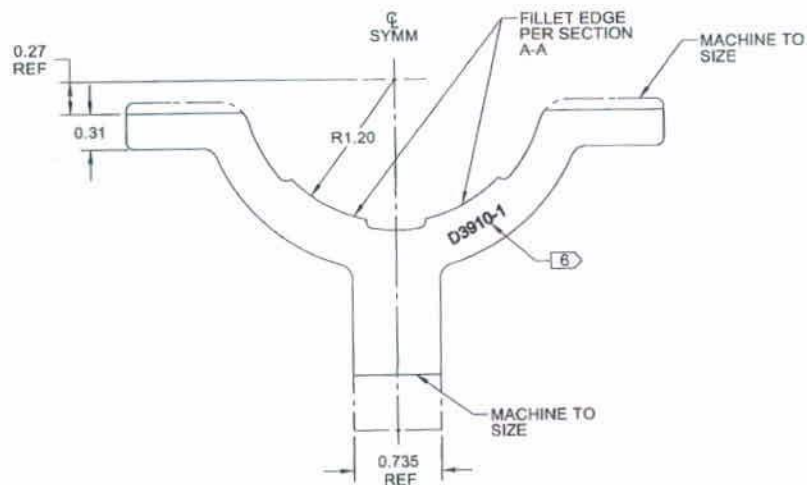


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2





W063333



D3910-1 X-TUBE LUG

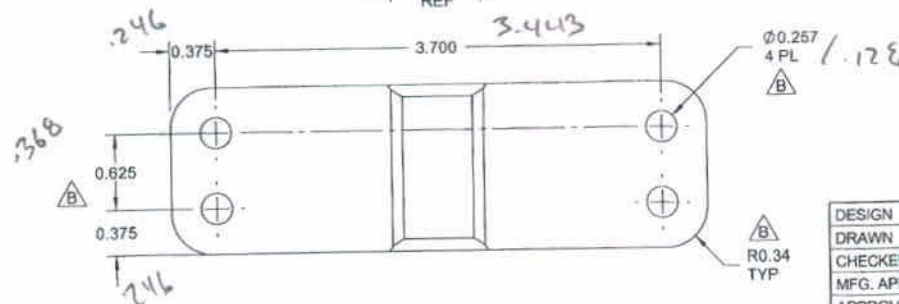
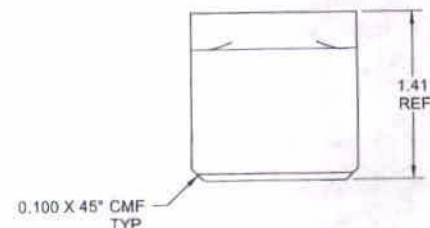
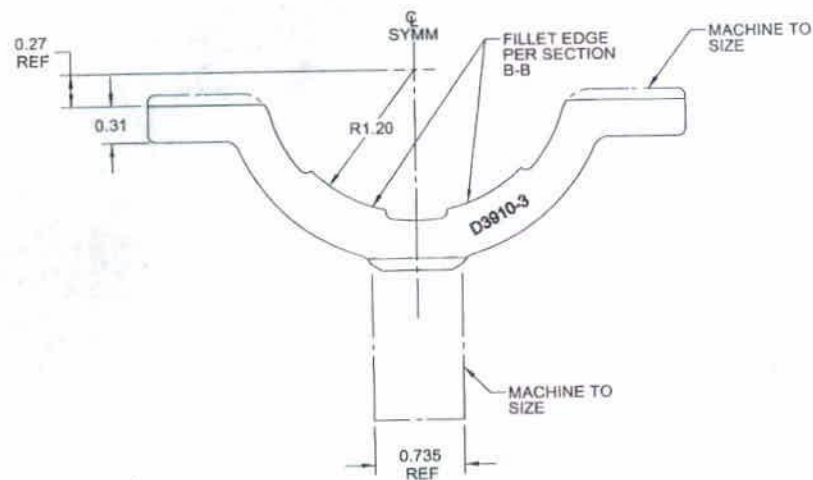
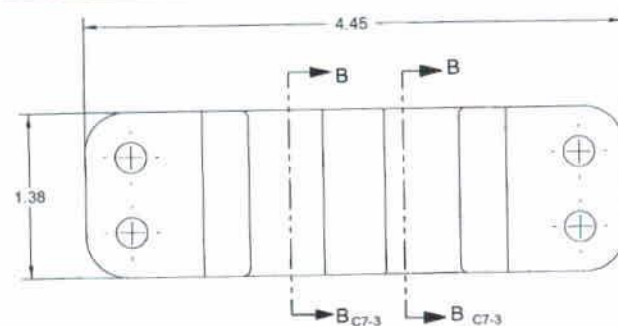
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2010-03-22

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DE APPR.		X-TUBE LUG (350)	NTS
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO13000

Purchase Order Date 11/24/10

PO Print Date 11/24/10

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name
Vendor Phone 613 678 3957
Vendor Fax 613 678 3956
Vendor Account Nbr

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
C/L 11/24

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3910-3P	Crosstube Lug	11/29/10 Yes	30.00 Each		\$31.5500	\$946.50
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B63333 REQUIRED ASAP PLEASE RUSH ORDER				
2	D3910-1P	CROSSTUBE LUG	12/01/10 Yes	20.00 Each		\$31.5500	\$631.00
		Special Inst:	MACHINE AS PER DWG D3910 REV. B B64016				
3	D2230-1P	LUG	12/06/10 Yes	60.00 Each		\$18.9500	\$1,137.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B63319				
4	D2230-3P	LUG	12/08/10 Yes	60.00 Each		\$10.4000	\$624.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 11/24/10

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

10

D3910-3

Crosstube Lug

13000

20

D3910-1

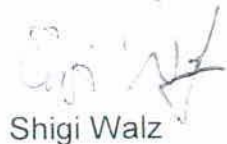
Crosstube Lug

13000

MATERIAL: supplied by DART D2423 B45800

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, November 29, 2010